



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-2704-00-1

Job Sheet 170952



Part No: RBE350A94-2704-00-1

Job Qty: 20 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-2704-00 Rev C IPP Rev A 18.01.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/30/18	1/30/18	0.00	0.00	Start Up Waterjet2		DE 18/02/05
100	Waterjet	12 pcs	1/30/18	1/30/18	0.08	1.00	Waterjet 2 OMAX		DE 18/02/05
110	QC	12 pcs	1/30/18	1/30/18	0.00	0.00	QC2 Waterjet-4		DE 18/02/05
120	QC	12 pcs	1/30/18	1/30/18	0.00	0.00	QC8-7		DE 18/02/05
130	Small Fab	12 pcs	1/31/18	1/31/18	0.25	1.00	Small Fab-9		GA 18-02-13
140	QC	12 pcs	1/31/18	1/31/18	0.00	0.00	QC5		GA 18-03-05
150	Outsource	12 pcs	1/31/18	1/31/18	0.00	0.00	Outsource12		GA 18-03-05
160	Packaging	12 pcs	1/31/18	1/31/18	0.00	0.00	Packaging2		GA 18-03-05
170	QC	12 pcs	1/31/18	1/31/18	0.00	0.00	QC6		GA 18-03-05
180	Packaging	12 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-2		GA 18-03-05
190	QC21-SA	12 Ea	1/31/18	1/31/18	0.00	0.00	QC21		GA 18-03-05

Part Op 130 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
Descriptions: 150 - Issue P/O to Groupe Altech; PO 039039 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of
Conformity is required
180 - Identify and Stock

FEB 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.188	Hot Rolled Steel Plate 0.1889" (44W)	.6600 sf (.055 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-HRS-P-0.188	1	15	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Job No: 170952 Operation 02/06/18	DISPOSITION Rework ☐ S039303 Plate	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width:15%;">Skid-tube</td> <td style="width:15%;">Cross tube</td> <td style="width:15%;">Water Jet</td> <td style="width:15%;">Engineering</td> </tr> <tr> <td>Machining</td> <td>Small Fab</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td>Forming</td> <td>Finishing</td> <td>Rec/Store/Packaging</td> <td>Other</td> </tr> <tr> <td>Large Fab</td> <td>Composite</td> <td>Supplier</td> <td></td> </tr> </table> QTY Effective : _____ Disposition MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	AGAINST DEPARTMENT/PROCESS				Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Forming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
AGAINST DEPARTMENT/PROCESS																						
Skid-tube	Cross tube	Water Jet	Engineering																			
Machining	Small Fab	Prod. Eng. Coord.	Quality																			
Forming	Finishing	Rec/Store/Packaging	Other																			
Large Fab	Composite	Supplier																				

FAULT CATEGORY	
ture/Cure ute Damage/Defect n Incomplete/Unqualified nation ink short ons Incomplete/Unclear s	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1P7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

8 7 6 5 4 3 2 1

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
C	TEMPLATE UPDATED, DIMENSION .36 CHANGED FOR 5/16" STANDARD DRILL SIZE. S/N & MADE IN USA REMOVED FROM ENGRAVING, CL SYM ADDED	17-806	18.1.2	VM	ML

D

C

B

A

5.13

CL SYM

1.57

CL SYM

.19

6

Ø .33 THRU ALL

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170952 MLT
1801-29

RBE350A94-2704-00-01 PLATE

NOTES:
1) MATERIAL: A36/1018/1020 HR
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE
4) SPEC: MIL-C-13924, CLASS 1; MIL-C-16173 GRADE 4
5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
6) IDENTIFICATION: ENGRAVE T/N "RBE350A94-2704-00"

DART
AEROSPACE
Hawkesbury, Ontario, Canada

TITLE
PLATE

PART NO. RBE350A94-2704-00-01 REV C

TOOL NO. RBE350A94-2704-00

DESIGNED BY: VM 18/01/02
DRAWN BY: VM 01/02/2018
CHECKED BY: VM 01/02/2018
MFG REVIEW BY: DD 01/03/2018
APPROVED BY: ML 01/03/2018

INITIALS AND DATE

TOLERANCES:
XX ±.004
XX ±.01
X ±.1

FRACTIONS ± 1/8
ANGLES 2.5°
SURFACE
ROUGHNESS

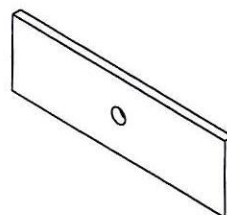
SCALE: NTS SHEET 2 OF 2

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8 7 6 5 4 3 2 1

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170952 ML3



RBE350A94-2704-00-01 PLATE

		Hawkesbury, Ontario, Canada	
TITLE			
PLATE			
PART NO.		REV	
RBE350A94-2704-00-01		C	
TOOL NO. RBE350A94-2704-00		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE AS SHOWN INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DETAILS AND DATE			
DESIGNED BY: VM 18/01/2012		TOLERANCES: .XX ± .04	
DRAWN BY: VM 01/02/2018		XX .21	
CHECKED BY: VM 01/02/2018		X 2.1	
MFG REVIEW BY: DD 01/03/2018		FRACTIONS 1/16	
APPROVED BY: MT 01/03/2018		ANGLES 2.5°	
		SURFACE	
		ROUGHNESS	
		SCALE: NTS	
		SHEET 2 OF 2	
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED OR FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT PERMISSION			
DART AEROSPACE COMPANY			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Appro																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervi																		
							Approval Verificatio																		
							QC / QA Coordinat																		
							Approval																		
Root Cause			FAULT CATEGORY																						
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensio ☐ Over/Under toler ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER

PO039039

Supplier:

GRO002-VC
Group Allech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To:

1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line	Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	Shim	170480	646.3911	Issue P/O: _____ Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	2/27/18	32 pcs	0 pcs	32 pcs	\$4.25/pcs	\$136.00
2	Seat	170958	RBE350A93-3312-03-5	Issue P/O to Groupe Allech; PO -Black oxide finish, MIL-C-13964, CLASS 1, MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	2/27/18	6 pcs	0 pcs	6 pcs	\$1.35/pcs	\$8.10
3	Washer	170959	RBE350A93-3312-03-7	Issue P/O to Groupe Allech; PO -Black oxide finish, MIL-C-13964, CLASS 1, MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	2/27/18	6 pcs	0 pcs	6 pcs	\$1.35/pcs	\$8.10
4	Plate	170952	RBE350A94-2704-00-1	Issue P/O to Groupe Allech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/27/18	20 pcs	0 pcs	20 pcs	\$3.89/pcs	\$77.80
5	Remover / Installer	170957	RBE350A93-3312-03-3	Issue P/O to Groupe Allech; PO -Black oxide finish, MIL-C-13964, CLASS 1, MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	2/27/18	6 pcs	0 pcs	6 pcs	\$1.35/pcs	\$8.10



Certificat de Conformité / Certificate of Compliance

(006931-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

006931 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Feb-2018		Aman Kaur		PO039039				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	646.3911 Rev.	646.3911 CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	32	32	0	0	0
2	RBE350A93-3312-03-5 Rev.	RBE350A93-3312-03-5 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	6	6	0	0	0
3	RBE350A93-3312-03-7 Rev.	RBE350A93-3312-03-7 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	6	6	0	0	0
4	RBE350A94-2704-00-1 Rev.	RBE350A94-2704-00-1 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	20	20	0	0	0
5	RBE350A93-3312-03-3 Rev.	RBE350A93-3312-03-3 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0
6	RBT400325 Rev.	RBT400325 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0
7	RBE8814164002 Rev.	RBE8814164002 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	1	1	0	0	0
8	RBE350A93-3307-00-01 Rev.	RBE350A93-3307-00-01 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.